

Work Order ID 135289

Tuesday, August 11, 2015 10:06:19 AM

135289

Page 1

Item ID: D3885-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Standard Web

Start Date: 8/11/2015 Start Qty: 8.00

8

Cust Item ID:

Required Date: 8/11/2015 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals: Process Plan: MLJ Date: AUG 11 2015 Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____

Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3885	B								

100

0.00

100

Purchasing

Memo

0.00

Purchasing

Purchasing

Issue P/O: 29459

Supplier: WEJAY

Machine as per Dwg D3885

Conformity sheet required

CL AUG 13 2015 8

110

Receive & Inspect for Damage & Mat'l Certs

0.00

110

Packaging

Memo

0.00

Packaging

8 DAS SEP 04 2015
06
9-89

Work Order ID 135289

135289

Page 2

Tuesday, August 11, 2015 10:06:19 AM

Item ID: D3885-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Standard Web
 Start Date: 8/11/2015 Start Qty: 8.00 ***8*** Cust Item ID:
 Required Date: 8/11/2015 Req'd Qty: 8.00 ***8*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC6- Inspect dimensions to drawing	0.00							
120									
QC	Memo	0.00							
Quality Control									
130	Chemical Conversion Coat per QSI005 4.1	0.00							
130									
HandFinish	Memo	0.00							
Hand Finishing									
140	QC7-Inspect Chemical Conversion Coat	0.00							
140									
QC	Memo	0.00							
Quality Control									

⑧ 15-09-04 PD
 8 15-9-8
 8 15-9-9

Work Order ID 135289

Tuesday, August 11, 2015 10:06:19 AM

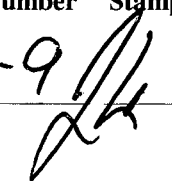
135289

Page 3

Item ID: D3885-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Standard Web
 Start Date: 8/11/2015 Start Qty: 8.00 ***8*** Cust Item ID:
 Required Date: 8/11/2015 Req'd Qty: 8.00 ***8*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location LG002	0.00							
150									
Packaging	Memo	0.00							
Packaging	LOCATION : LG002								
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

15-9-9 

MCW SEP 16 2015

SW 20150815

Picklist Print

Tuesday, August 11, 2015 10:06:23 AM

Page 1

Work Order ID: 135289

135289

Parent Item: D3885-1

D3885-1

Parent Item Name: Standard Web

Start Date: 8/11/2015

Required Date: 8/11/2015

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3885-1P		Purchased	No				Each	0.0000		8			
D3885-1P									**				
Standard Web													
D3882-1-130		Manufactured	No			110	Each	42.0000	1	8			
D3882-1-130									**				
Extrusion "I" Beam													

Location

Loc Qty

Loc Code

LG002

119702

42

42

8 DGC 15-8-12

SEP 04 2015

11/10/00
10/10/00

0.135 289 MLS
1508-11

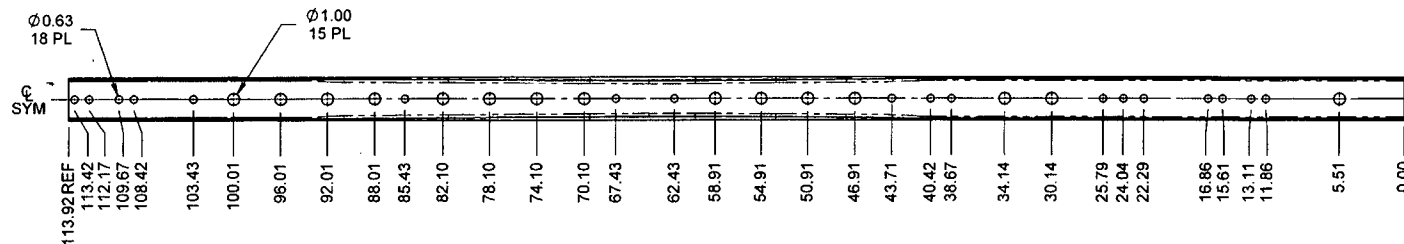
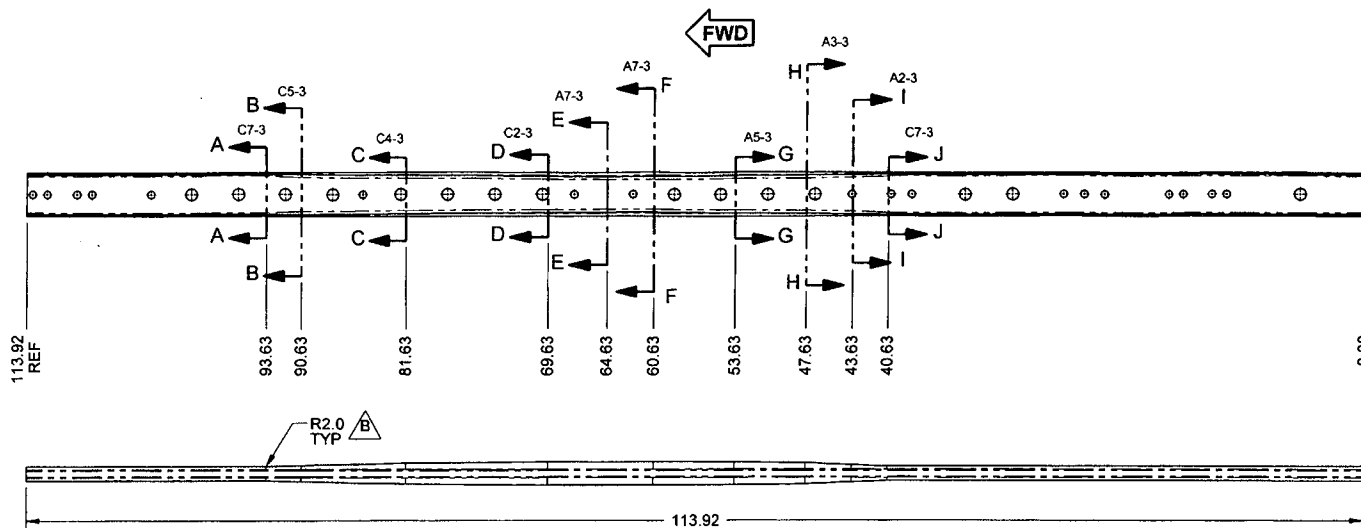
D3885-1 STANDARD WEB

D3885-3 FLOAT WEB

RELEASED
9/6/00

B	ADD 0.32 (ZN D7-3, D5-3, D7-5, D5-5); ADD 0.24 (ZN B2-3, B3-5), ADD R2.0 TYP (ZN C6-2 & C6-4)	RF	09.06.30
A	NEW ISSUE	RF	09.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D3885	SHEET 1 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	WEB	NTS
DATE	09.06.30	COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

8 7 6 5 4 3 2 1



D3885-1 STANDARD WEB

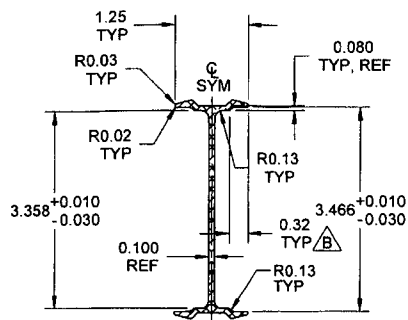
RELEASED
2017/15/10

D3885-1 NOTES:

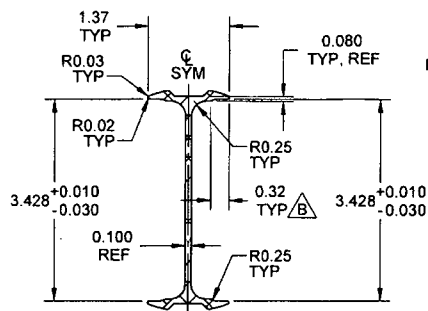
- 1) MATERIAL: MAKE FROM D3882-1-130 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3885-1" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 8.51 lbs

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3885	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		WEB	NTS
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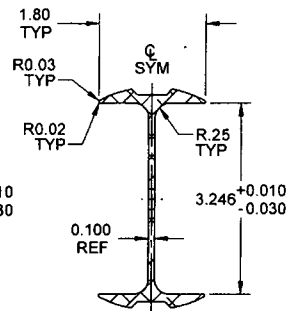
8 7 6 5 4 3 2 1



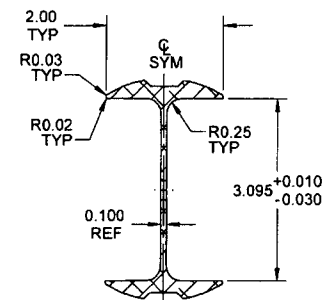
**SECTION A-A
& SECTION J-J** D6-2
D4-2
SCALE 5X



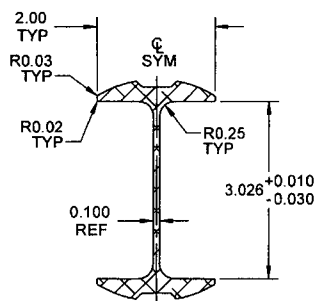
SECTION B-B D6-2
SCALE 5X



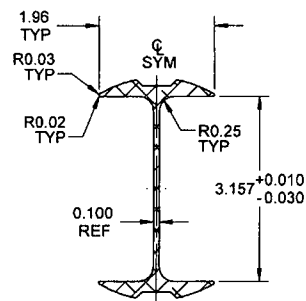
SECTION C-C D6-2
SCALE 5X



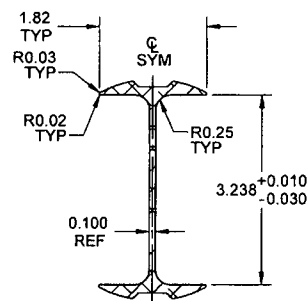
SECTION D-D D5-2
SCALE 5X



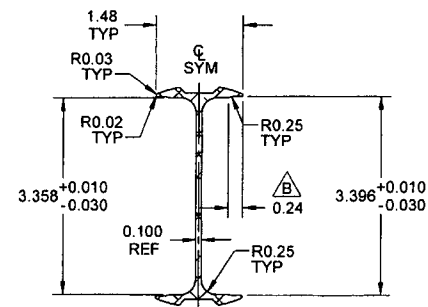
**SECTION E-E
& SECTION F-F** D5-2
SCALE 5X



SECTION G-G D4-2
SCALE 5X



SECTION H-H D4-2
SCALE 5X

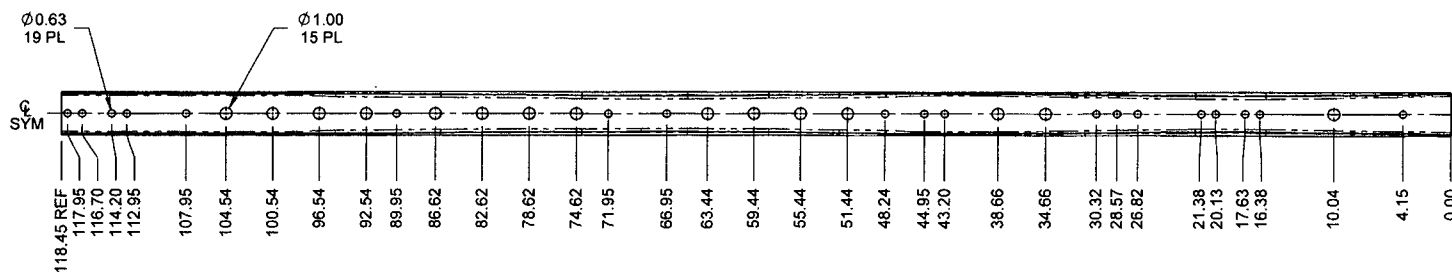
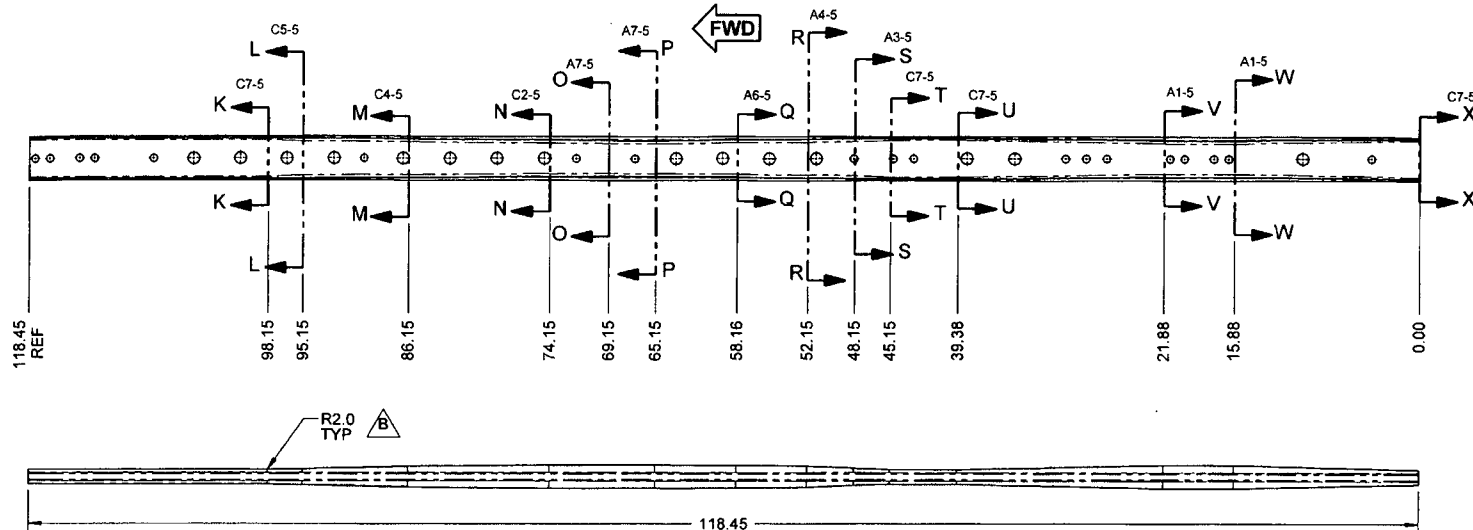


SECTION I-I D4-2
SCALE 5X

D3885-1 STANDARD WEB SECTION VIEWS

RELEASED
07/15/2009

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3885	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		WEB	NTS
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D3885-3 FLOAT WEB

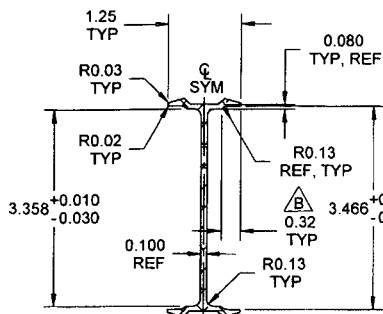
D3885-3 NOTES:

- 1) MATERIAL: MAKE FROM D3882-1-130 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3885-3" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 10.14 lbs

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3885	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		WEB	NTS
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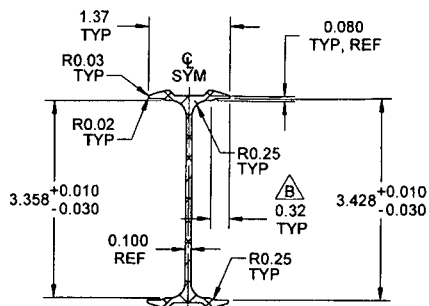
RELEASED
09/07/15 AN

8 7 6 5 4 3 2 1

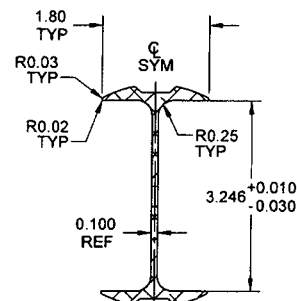


**SECTION K-K
& SECTION T-T
& SECTION U-U
& SECTION X-X**
SCALE 5X

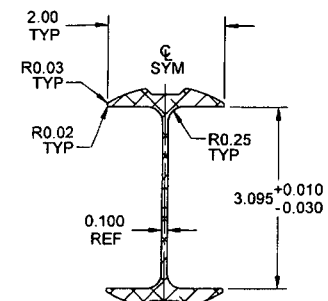
D7-4
D4-4
D3-4
D1-4



SECTION L-L D6-4
SCALE 5X

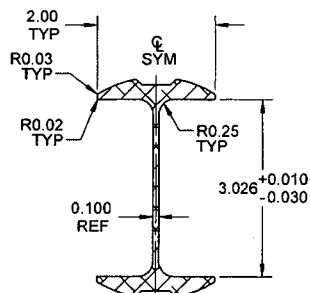


SECTION M-M D6-4
SCALE 5X

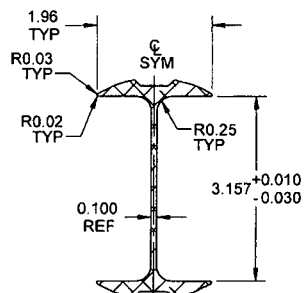


SECTION N-N D5-4
SCALE 5X

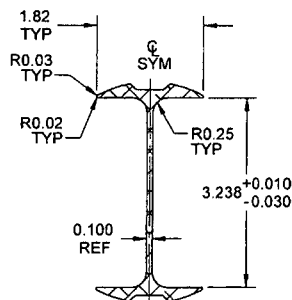
RELEASED
8/27/51



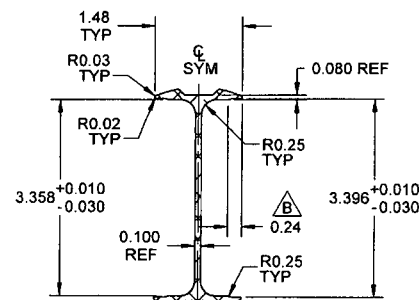
**SECTION O-O
& SECTION P-P** D5-4
SCALE 5X



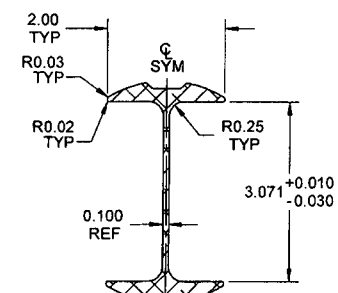
SECTION Q-Q D4-4
SCALE 5X



SECTION R-R D4-4
SCALE 5X



SECTION S-S D4-4
SCALE 5X



**SECTION V-V
& SECTION W-W** D3-4
D2-4
SCALE 5X

D3885-3 FLOAT WEB SECTION VIEWS

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.		D3885	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		WEB	NTS
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8 7 6 5 4 3 2 1



600 O'CONNOR DRIVE, KINGSTON, ONTARIO K7P 1N3

PHONE: (613) 384-1662

FAX: (613) 384-2997

CERTIFICATE OF COMPLIANCE

CUSTOMER: Dart Aerospace

DATE: Sept. 3, 2015

P.O.# PO29454

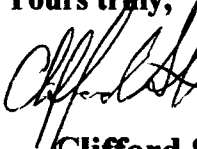
WEJAY JOB# 37503

I hereby certify that the following material has been inspected/tested and conforms to the requirements and specifications as stated in your contract and as noted below.

PART NO.	QTY.	PROCESS (ES)	SPECIFICATION / REV
D3885-1P 'Standard Web' B135286	8	Machined complete per drawing req'ts.	D-3885 / rev. B
D3885-3P 'Float Web' B135288	7	Machined complete per drawing req'ts.	D-3885 / rev. B

Records of Inspection/Test will be retained for 5 years minimum.

Yours truly,


Clifford Smith
Authorized Q.A. Signatory





600 O'CONNOR DRIVE
KINGSTON, ONTARIO
K7P 1N3

INSPECTION / TEST REPORT

JOB No. 37503

PAGE: 1 of 3

CUSTOMER: Dart Aerospace

CUST. P.O.# PO291514

PART No. D3885-1P

DESCRIPTION: Standard Web

DWG No. D3885 - sheets 2-3

REV. B

E.C.O. --

MATERIAL: Extrusions supplied by DAS

INSPECTOR: *[Signature]*

QUANTITY
REC'D: 1

ACCEPT: 1

REJECT: --

N.C.R.# --

DATE: SEPT 1/15

INSTRUCTIONS, COMMENTS:

1ST ARTICLE

ITEM REF. No.	CHARACTERISTIC	DETAILS	TOLERANCE	DWG SHT/ZONE	RESULT	QTY. INSP.	COMMENTS (ACC. REJ. REW. NMR #)
---------------------	----------------	---------	-----------	-----------------	--------	---------------	---------------------------------------

1	Hole, Diameter .63"	18 places	+0.008/-0.001		0.632-0.633	1	ACC.
2	Hole, Diameter 1.00"	15 places	+0.010/-0.001		1.000-1.002	1	"
3	5.51"		+/- .03		5.513	1	"
4	11.86"		+/- .03		11.864	1	"
5	13.11"		+/- .03		OK	1	"
6	15.61"		+/- .03		OK	1	"
7	16.86"		+/- .03		OK	1	"
8	22.29"		+/- .03		OK	1	"
9	24.04"		+/- .03		OK	1	"
10	25.79"		+/- .03		OK	1	"
11	30.14"		+/- .03		OK	1	"
12	34.14"		+/- .03		OK	1	"
13	38.67"		+/- .03		OK	1	"
14	40.42"		+/- .03		OK	1	"
15	43.71"		+/- .03		OK	1	"
16	46.91"		+/- .03		OK	1	"
17	50.91"		+/- .03		OK	1	"
18	54.91"		+/- .03		OK	1	"
19	58.91"		+/- .03		OK	1	"
20	62.43"		+/- .03		OK	1	"
21	67.43"		+/- .03		OK	1	"
22	70.10"		+/- .03		OK	1	"
23	74.10"		+/- .03		OK	1	"
24	78.10"		+/- .03		OK	1	"
25	82.10"		+/- .03		OK	1	"
26	85.43"		+/- .03		OK	1	"
27	88.01"		+/- .03		OK	1	"
28	92.01"		+/- .03		OK	1	"
29	96.01"		+/- .03		OK	1	"
30	100.01"		+/- .03		OK	1	"
31	103.43"		+/- .03		OK	1	"
32	108.42"		+/- .03		OK	1	"

INSPECTION / TEST REPORT

JOB No. 37503

PAGE: 2 of 3

CUSTOMER: Dart Aerospace

CUST. P.O. PO29454

PART No. D3885-1

DESCRIPTION: Standard Web

DWG No. D3885 - sheets 2-3

REV. B

E.C.O. --

REF. No.	CHARACTERISTIC	DETAILS	TOLERANCE	DWG SHT/ZONE	RESULT	QTY. INSP.	COMMENTS (ACC. REJ. REW. NMR #)
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33	109.67"		+/- .03		OK	1	ACC.
34	112.17"		+/- .03		OK	1	"
35	113.42"		+/- .03		OK	1	"
36	113.92" o.a.		+/- .03		OK	1	"
37	1.25" TYP	Section A-A, J-J	+/- .03		1.250-1.265	1	"
38	R.03" TYP				OK	1	"
39	R.02" TYP				OK	1	"
40	3.358"		+0.010/-0.030		3.355-3.361	1	"
41	R.13" TYP				OK	1	"
42	.32" TYP		+/- .03		OK	1	"
43	3.466"		+0.010/-0.030		3.460-3.470	1	"
44	R.13" TYP				OK	1	"
45	.080 TYP, REF				0.08-0.09	1	"
46	1.37" TYP	Section B-B	+/- .03		1.372-1.387	1	"
47	R.03" TYP				OK	1	"
48	R.02" TYP				OK	1	"
49	3.358 3.428		+0.010/-0.030		3.420-3.430	1	"
50	R.25" TYP				OK	1	"
51	.32" TYP		+/- .03		.315	1	"
52	R.25" TYP				OK	1	"
53	3.428 3.358		+0.010/-0.030		3.352-3.360	1	"
54	1.80" TYP	Section C-C	+/- .03		1.798-1.800	1	"
55	R.03" TYP				OK	1	"
56	R.02" TYP				OK	1	"
57	3.246"		+0.010/-0.030		3.235-3.246	1	"
58	R.25" TYP				OK	1	"
59	2.00" TYP	Section D-D	+/- .03		1.985-1.986	1	"
60	R.03" TYP				OK	1	"
61	R.02" TYP				OK	1	"
62	3.095"		+0.010/-0.030		3.088-3.086	1	"
63	R.25" TYP				OK	1	"
64	2.00" TYP	Section E-E, F-F	+/- .03		1.986-1.988	1	"
65	R.03" TYP				OK	1	"
66	R.02" TYP				OK	1	"
67	3.026"		+0.010/-0.030		3.02-3.04 (stock)	1	9/5 ACC.
68	R.25" TYP				OK	1	ACC.
69	1.96"	Section G-G	+/- .03		1.967-1.970	1	"
70	R.03" TYP				OK	1	"
71	R.02" TYP				OK	1	"

JOB No.

REF. No.	CHARACTERISTIC	DETAILS	TOLERANCE	DWG SHT/ZONE	RESULT	QTY. INSP.	COMMENTS (ACC. REJ. REW. NMR #)
-------------	----------------	---------	-----------	-----------------	--------	---------------	---------------------------------------

FORM WJM033 JUN25/09



600 O'CONNOR DRIVE
KINGSTON, ONTARIO
K7P 1N3

INSPECTION / TEST REPORT

JOB No. 37503

PAGE: 1 of 3

CUSTOMER: Dart Aerospace

CUST. P.O.# PO29454

PART No. D3885-3P

DESCRIPTION: Float Web

DWG No. D3885 - sheets 4-5

REV. B

E.C.O. --

MATERIAL: Extrusions supplied by DAS

INSPECTOR:

CLIFF SMITH

QUANTITY
REC'D: 1

ACCEPT: 1

REJECT: -

N.C.R.# --

DATE:

AUG 31/15

INSTRUCTIONS, COMMENTS:

2ND PC.

ITEM REF. No.	CHARACTERISTIC (DIMS IN mm)	DETAILS	TOLERANCE	DWG SHT/ZONE	RESULT	QTY. INSP.	COMMENTS (ACC. REJ. REW. NMR #)
---------------------	--------------------------------	---------	-----------	-----------------	--------	---------------	---------------------------------------

1	Hole, Diameter .63"	19 places	+0.008/-0.001		.632 - .633	1	ACC.
2	Hole, Diameter 1.00"	15 places	+0.010/-0.001		1.001 - 1.002	1	"
3	4.15"		+/- .03		4.153	1	"
4	10.04"		+/- .03		O.K.	1	"
5	16.38"		+/- .03		O.K.	1	"
6	17.63"		+/- .03		O.K.	1	"
7	20.13"		+/- .03		O.K.	1	"
8	21.38"		+/- .03		O.K.	1	"
9	26.82"		+/- .03		O.K.	1	"
10	28.57"		+/- .03		O.K.	1	"
11	30.32"		+/- .03		O.K.	1	"
12	34.66"		+/- .03		O.K.	1	"
13	38.66"		+/- .03		O.K.	1	"
14	43.20"		+/- .03		O.K.	1	"
15	44.95"		+/- .03		O.K.	1	"
16	48.24"		+/- .03		O.K.	1	"
17	51.44"		+/- .03		O.K.	1	"
18	55.44"		+/- .03		O.K.	1	"
19	59.44"		+/- .03		O.K.	1	"
20	63.44"		+/- .03		O.K.	1	"
21	66.95"		+/- .03		O.K.	1	"
22	71.95"		+/- .03		O.K.	1	"
23	74.62"		+/- .03		O.K.	1	"
24	78.62"		+/- .03		O.K.	1	"
25	82.62"		+/- .03		O.K.	1	"
26	86.62"		+/- .03		O.K.	1	"
27	89.95"		+/- .03		O.K.	1	"
28	92.54"		+/- .03		O.K.	1	"
29	96.54"		+/- .03		O.K.	1	"
30	100.54"		+/- .03		O.K.	1	"
31	104.54"		+/- .03		O.K.	1	"
32	107.95"		+/- .03		O.K.	1	"
33	112.95"		+/- .03		O.K.	1	"
34	114.20"		+/- .03		O.K.	1	"
35	116.70"		+/- .03		O.K.	1	"

INSPECTION / TEST REPORT

JOB No. 37503

PAGE: 2 of 3

CUSTOMER: Dart Aerospace

CUST. P.O. PO29454

PART No. D3885-3

DESCRIPTION: Float Web

DWG No. D3885 - sheets 4-5

REV. B

E.C.O. --

REF. No.	CHARACTERISTIC	DETAILS	TOLERANCE	DWG SHT/ZONE	RESULT	QTY. INSP.	COMMENTS (ACC. REJ. REW. NMR #)
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36	117.95"		+/- .03		0-K.	1	Acc.
37	1.25" TYP	Section K-K,T-T,U-U,X-X			1.257/1.274	1	"
38	R.03" TYP				0-K.	1	"
39	R.02" TYP				0-K.	1	"
40	3.358"		+0.010/-0.030		3.337/3.363	1	"
41	R.13" TYP				0-K.	1	"
42	.32" TYP				.328/.334	1	"
43	3.466"		+0.010/-0.030		3.448/3.473	1	"
44	R.13" TYP				0-K.	1	"
45	.080 TYP, REF				0-K.	1	"
46	1.37" TYP	Section L-L			1.369/1.397	1	"
47	R.03" TYP				0-K.	1	"
48	R.02" TYP				0-K.	1	"
49	3.358"		+0.010/-0.030		3.356/3.358	1	"
50	R.25" TYP				0-K.	1	"
51	.32" TYP				.326/.338	1	"
52	R.25" TYP				0-K.	1	"
53	3.428"		+0.010/-0.030		3.423/3.435	1	"
54	1.80" TYP	Section M-M			1.810/1.813	1	"
55	R.03" TYP				0-K.	1	"
56	R.02" TYP				0-K.	1	"
57	3.246"		+0.010/-0.030		3.235/3.251	1	"
58	R.25" TYP					1	"
59	2.00" TYP	Section N-N			1.984/1.985 (STOCK)	1	"
60	R.03" TYP				0-K.	1	"
61	R.02" TYP				0-K.	1	"
62	3.095"		+0.010/-0.030		3.085/3.100	1	"
63	R.25" TYP				0-K.	1	"
64	2.00" TYP	Section O-O,P-P			1.984/1.985 (STOCK)	1	"
65	R.03" TYP				0-K.	1	"
66	R.02" TYP				0-K.	1	"
67	3.026"		+0.010/-0.030		3.020/3.040 (STOCK)	1	"
68	R.25" TYP				0-K.	1	"
69	1.96"	Section Q-Q			1.971/1.978	1	"
70	R.03" TYP				0-K.	1	"
71	R.02" TYP				0-K.	1	"
72	3.157		+0.010/-0.030		3.148/3.163	1	"
73	R.25" TYP				0-K.	1	"
74	1.82"	Section R-R			1.824/1.835	1	"

